



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-636-022
Job Sheet 196276



Part No: D350-636-022

Job Qty: 1 pcs

Part Name: AS350/355 - Skidtubes - Standard w/ Standard Wearplates - RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/11/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 7/19/19

Description: SIOP

Type: Stock

Note: D2750-052 REV.H, IIN-D350-636 REV.K IPP REV.A 18.11.27 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Skidtubes - 1	1 pcs	7/19/19		0.00	0.00	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
110	Skidtubes - 2 - B4B	1 pcs	7/19/19		0.00	4.36	Skidtubes - 1 - B4B		
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
120	QC 10	1 pcs	7/19/19		0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
130	QC 5	1 pcs	7/19/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		

Plex 6/11/19 8:27 AM Dart.lajeunesse.marie

140 Handfinish - 1-1 Chemical-B4B	1 pcs	7/19/19	0.00 0.91	QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	1 pcs	7/19/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	

★ JUN 26 2019

BE

					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
160 Skidtubes - 3 - B4B	1 pcs	7/19/19	0.00 4.36	Skidtubes - 1 - B4B		DO
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		
				Skidtubes - 4 - B4B		
				Skidtubes - 5 - B4B		BE
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
170 QC 10	1 pcs	7/19/19	0.00 0.00	QC 10 - 10		
				QC 10 - 18		
				QC 10 - 24		
				QC 10 - 43	DAS 24 9-89	JUL 16 2019
				QC 10 - 50		
				QC 10 - 58		
				QC 10 - 9		
180 QC 5	1 pcs	7/19/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		DAS 40 9-89
190 Handfinish - 2-1 Pressure-B4B	1 pcs	7/19/19	0.00 0.91	Handfinish - 2 - 1 - B4B		JUL 16 2019
				Handfinish - 2 - 2 - B4B		★ JUL 15 2019
				Handfinish - 2 - 3 - B4B		
				Handfinish - 2 - 4 - B4B		
200 Spray Paint - 2 - B4B	1 pcs	7/19/19	0.00 0.69	Spray Paint - 1 - B4B		★ AS 19-7-18
				Spray Paint - 2 - B4B		
				Spray Paint - 3 - B4B		
				Spray Paint - 4 - B4B		
202 QC 14	1 pcs	7/19/19	0.00 0.00	QC 14 - 15		JUL 19-7-19
				QC 14 - 2		
				QC 14 - 34		
				QC 14 - 41		
				QC 14 - 51		
				QC 14 - 58		
				QC 14 - 59		
				QC 14 - 9		
				QC 14 - 68		
				QC 14 - 40		
				QC 14 - 19		

				QC 14 - 43	
				QC 14 - 24	
230 Handfinish - 4-1-Assembly-B4B	1 pcs	7/19/19	0.00 1.33	Handfinish - 4 - 1 - B4B	rel 14-8-13
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
240 QC 5	1 pcs	7/19/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
250 Packaging 1-1 - Pick Kit - B4B	1 pcs	7/19/19	0.00 0.00	Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	NC
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	

					Packaging 1 - 21 - B4B	
					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	
					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36 - B4B	
260 QC 4	1 pcs	7/19/19	0.00 0.00	QC 4 - 28		
				QC 4 - 58	Sms	
				QC 4 - 69	19/6/24	
				QC 4 - 9		
				QC 4 - 46		
				QC 4 - 68		
				QC 4 - 72		
				QC 4 - 74		
270 Packaging 3-1 - Stock - B4B	1 pcs	7/19/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B	Sms	
				Packaging 3 - 8 - B4B	19/6/24	
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		

Plex 6/11/19 8:27 AM Dart.lajeunesse.marie

275 DC - 1 - B4B	1 pcs	7/19/19	0.00 0.00	Packaging 3 - 36 - B4B	
				DC - 1 - B4B	
280 QC 21 - FG	1 pcs	7/19/19	0.00 0.00	DC - 2 - B4B	
				QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - FG - 53	

AUG 26 2019

DAS
70
9-89

Part Op 90 - ISSUE S/N No labor cost associated with this operation

Descriptions: 110 - 1- Pick D2600-3 Bent Drill pilot holes as per Dwg D2750 (D2750-6 details). Drill using drill Jlg DT8150. 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 7- Open up holes of Detail BM to 0.297" (total of 2 holes per side) and one 0.201" each side as per dwg 8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 9- Grind welds flush as per Dwg D2750 HR 1390 11

120 - (QC10- Inspect visual per QSI004- ground welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 160 - 1- Open up holes of Detail BN using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 4- Chamfer holes of Detail BN, ground handling and float holes per dwg D2750 (welding instructions on sheet 16)
 5- Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7- Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 5163437 exp. date: 12-09-2019 ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: m139011 10-Grind welds flush as per Dwg D2750 11- Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 12- Deburr holes, ensure tube is free of all scratches before sending to paint.
 170 - (QC10- Inspect visual per QSI004- ground welds)
 180 - (QC5- Inspect part completeness to step on W/O) ***VERIFY C'BOARD IS GOOD***
 190 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.
 200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5189559 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5192331
 202 - (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024
 230 - Assemble as per dwg) 1-Install inserts as per dwg D2750 2-Inspect for Foreign Objects 3-Install blade fitting D3488-4, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: _____ EXP DATE: _____ 5-Coat all exposed fasteners with "LPS Procyon" batch: _____
 240 - (QC5- Inspect part completeness to step on W/O)
 260 - (QC4- 100% Inspect kits for completeness)
 270 - (Identify as per dwg & Stock Location: _____) Package as per PPP D350-636-012
 275 - record fwd angle: 8.60° Photocopy blue file and type labels per PPP D350-636-012 CHG 008
 280 - (QC21- Final Inspection - Work Order Release)

Job BOM

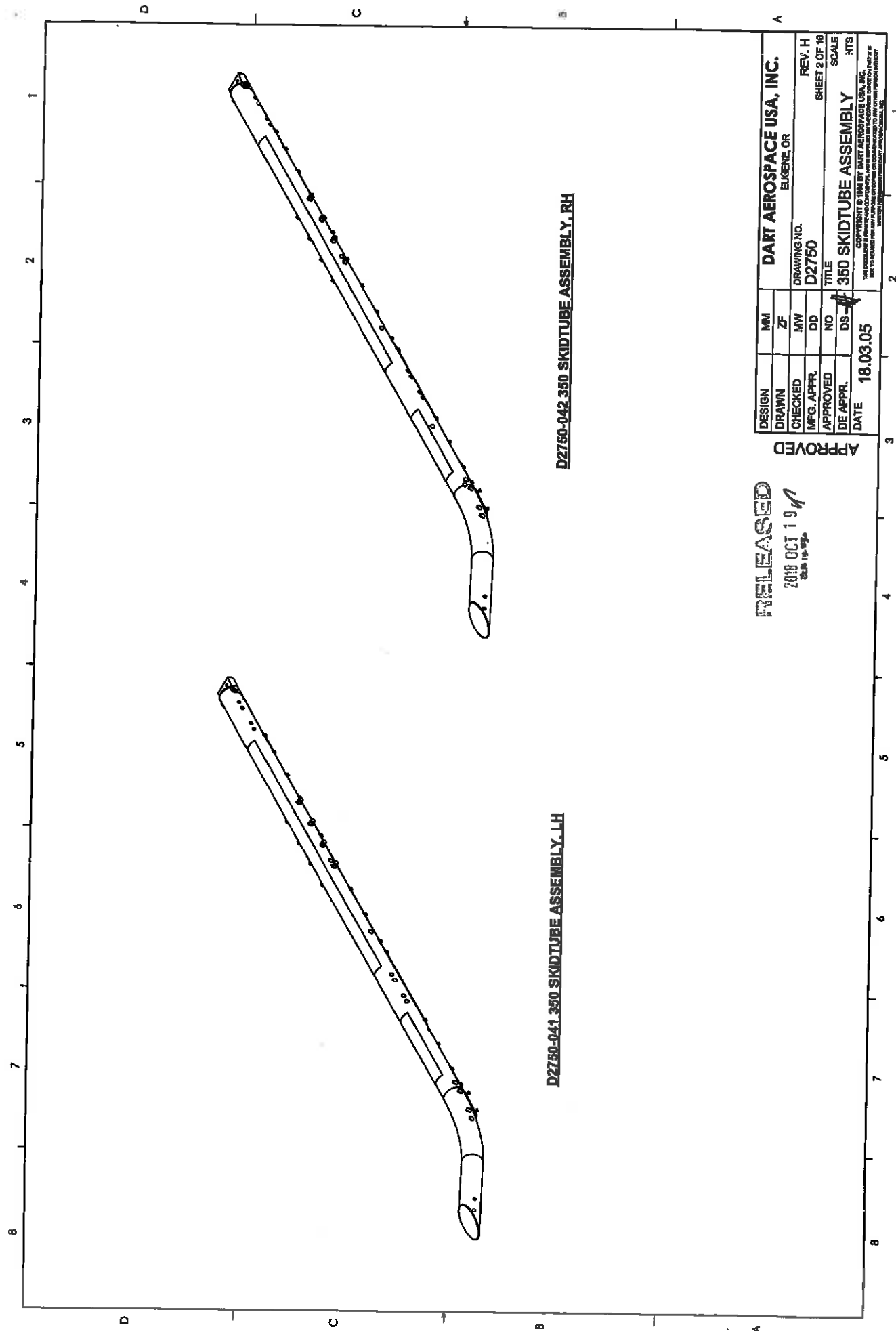
Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-RH	Extrusion Bent RH	1 pcs (1 ea)	90-Skidtubes - 1	5182195
D2744	Cap	1 pcs (1 ea)	110-Skidtubes - 2 - B4B	5192776
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes - 3 - B4B	5183022
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes - 3 - B4B	5182366
AN3C5A	Bolt	34 Ea (34 ea)	230-Handfinish - 4-1-Assembly-B4B	5192141
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5167183
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5181403
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5167090
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5188184
D3488-4	Blade Fitting, RH	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5185284
D3537-1	Wearpad	3 pcs (3 ea)	230-Handfinish - 4-1-Assembly-B4B	5195622(2)
D3631-1	Washer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5184192
D3791-1	Wearpad	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5189076
D3793-1	Wearplate Fwd	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5187308
D3793-3	Wearplate Aft	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5202008
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5181777
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5167203-1
NAS1149C0332R	Washer	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B	5158070
NAS1149C0832R	Washer	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5076017
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5088509
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B	5174308
AN3C34A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5189162
D3793-5	Wearpad	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5186091-1
MS21043-3	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5095569
NAS1149C0363R	Washer	2 Ea (2 ea)	230-Handfinish - 4-1-Assembly-B4B	5135100
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5183309
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5194663
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5167103
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5166118

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Skidtubes - 1	D2600-3-BENT-RH	1	5	0
110-Skidtubes - 2 - B4B	D2744	1	0	0
160-Skidtubes - 3 - B4B	D2739	1	17	0
	D2743	8	167	0
230-Handfinish - 4-1-Assembly-B4B	ALS4-1032-225	38	949	0
	AN3C34A	1	43	0
	AN3C5A	34	1,084	0
	AN3C6A	4	205	0
	AN6C44A	4	166	0
	AN8C35A	1	35	0
	D2745	8	168	0
	D3488-4	1	19	0
	D3537-1	3	56	0
	D3631-1	8	492	0
	D3791-1	1	2	0
	D3793-1	1	17	0
	D3793-3	1	13	0
	D3793-5	1	0	0
	MS21043-3	1	1,215	0
	MS21043-6	4	159	0
	MS21083C8	1	110	0
	NAS1149C0332R	38	2,780	0
	NAS1149C0363R	2	765	0
	NAS1149C0832R	1	313	0
	NAS1515H3L	4	234	0
250-Packaging 1-1 - Pick Kit - B4B	AN8C21A	2	157	0
	D2741	1	41	0
	MS21083C8	2	110	0
	NAS1149D0863J	2	407	0

Part Specifications
Specifications could not be found.

Plex 6/11/19 8:27 AM Dart.lajeunesse.marie



D2750-042 350 SKIDTUBE ASSEMBLY, RH

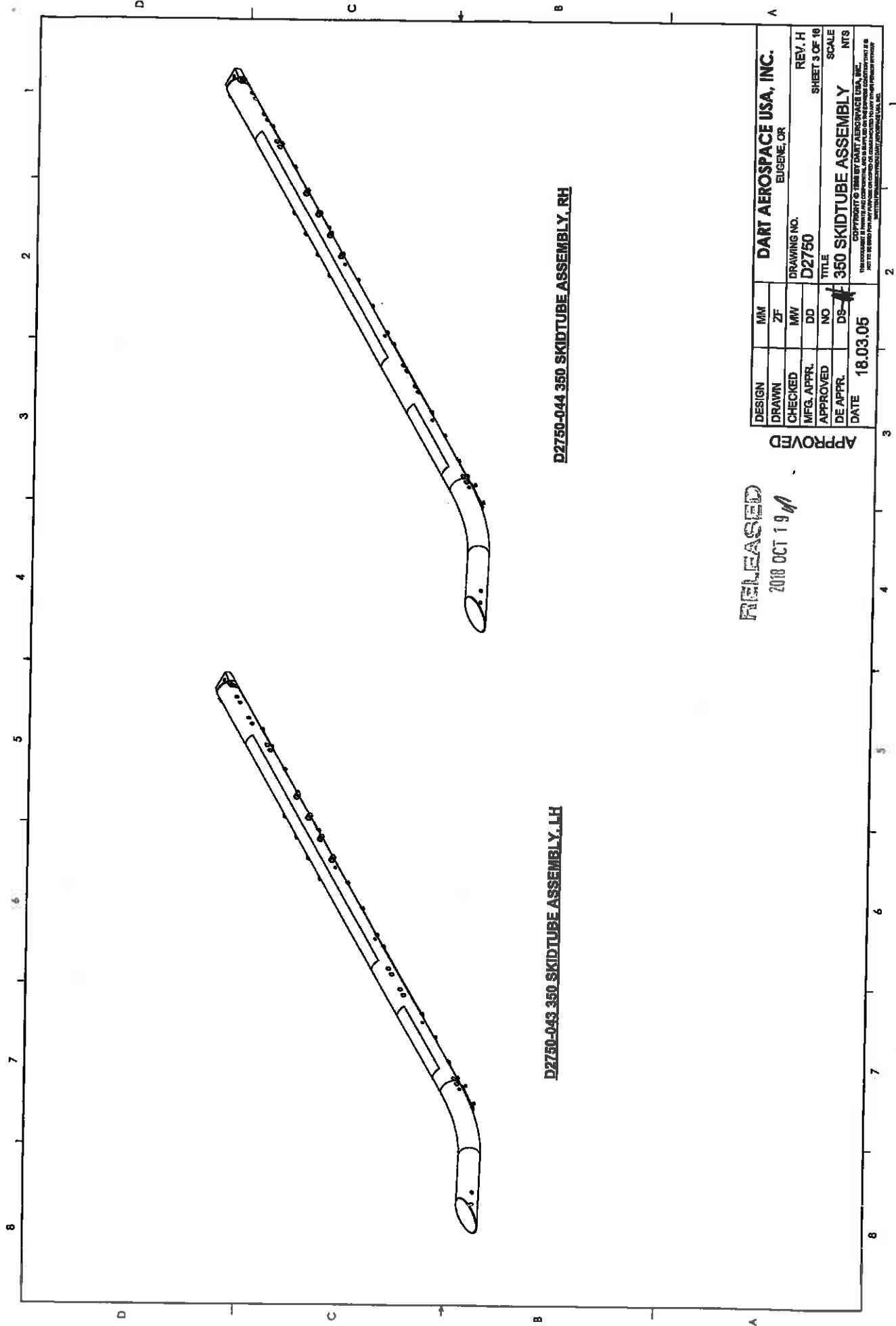
D2750-041 350 SKIDTUBE ASSEMBLY, LH

RELEASED
2018 OCT 19
EIA 14-002

APPROVED

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	D2750
MFG. APPR.	DD	REV. H	SHEET 2 OF 18
APPROVED	NO	TITLE	350 SKIDTUBE ASSEMBLY
DATE	18.03.05	SCALE	NTS

COPYRIGHT © 1984 BY DART AEROSPACE USA, INC.
THIS DRAWING IS THE PROPERTY OF DART AEROSPACE USA, INC. AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.



D2750-043 350 SKIDTUBE ASSEMBLY, LH

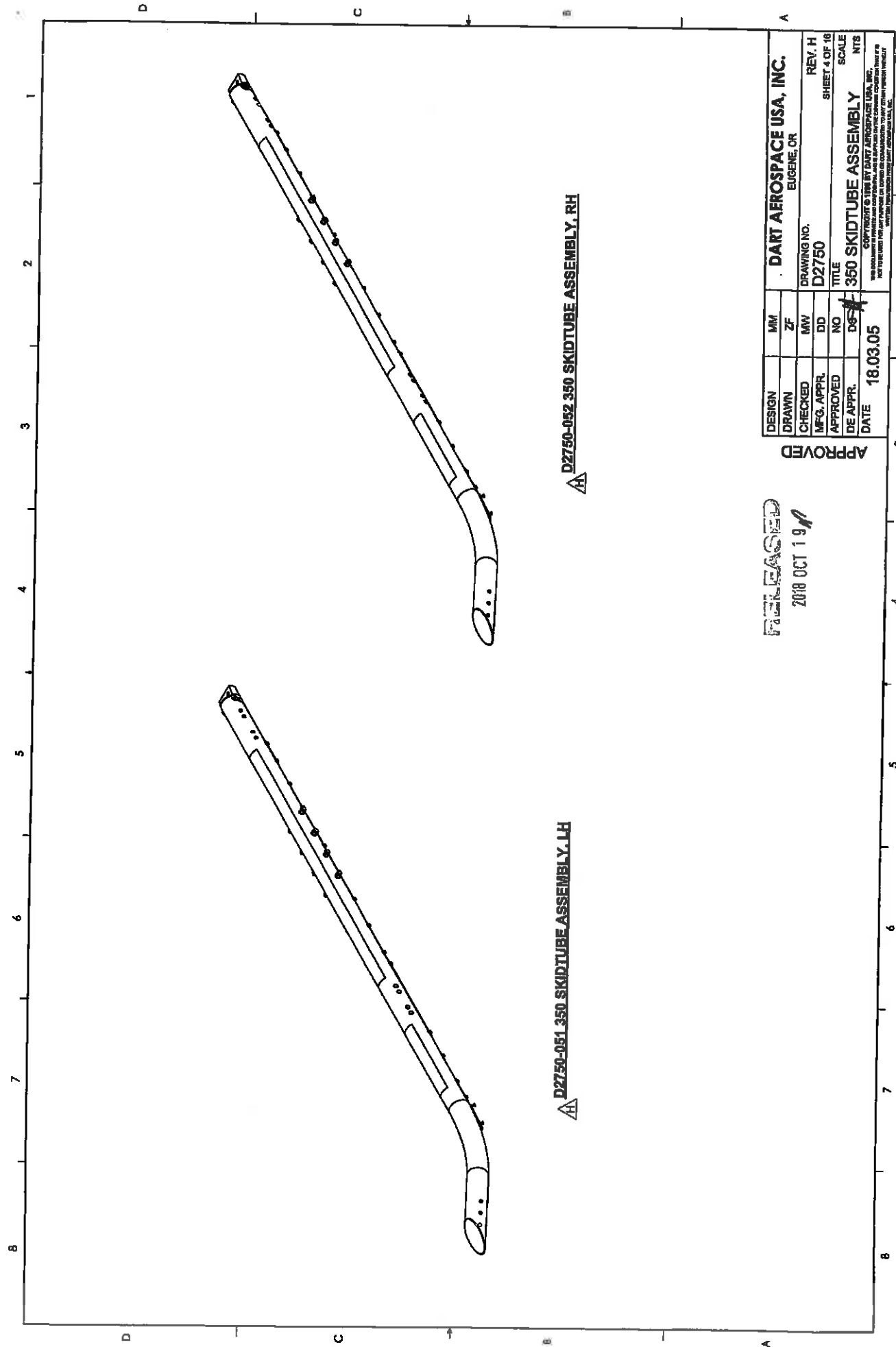
D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2018 OCT 19

APPROVED

DESIGN		MM	DART AEROSPACE USA, INC.	
DRAWN		ZF	EUGENE, OR	
CHECKED	MM	DRAWING NO.	D2750	
MFG. APPR.	DD	TITLE	350 SKIDTUBE ASSEMBLY	
APPROVED	NO	REV. H	SHEET 3 OF 18	
DE APPR.	DS	SCALE	NTS	
DATE	18.03.05			

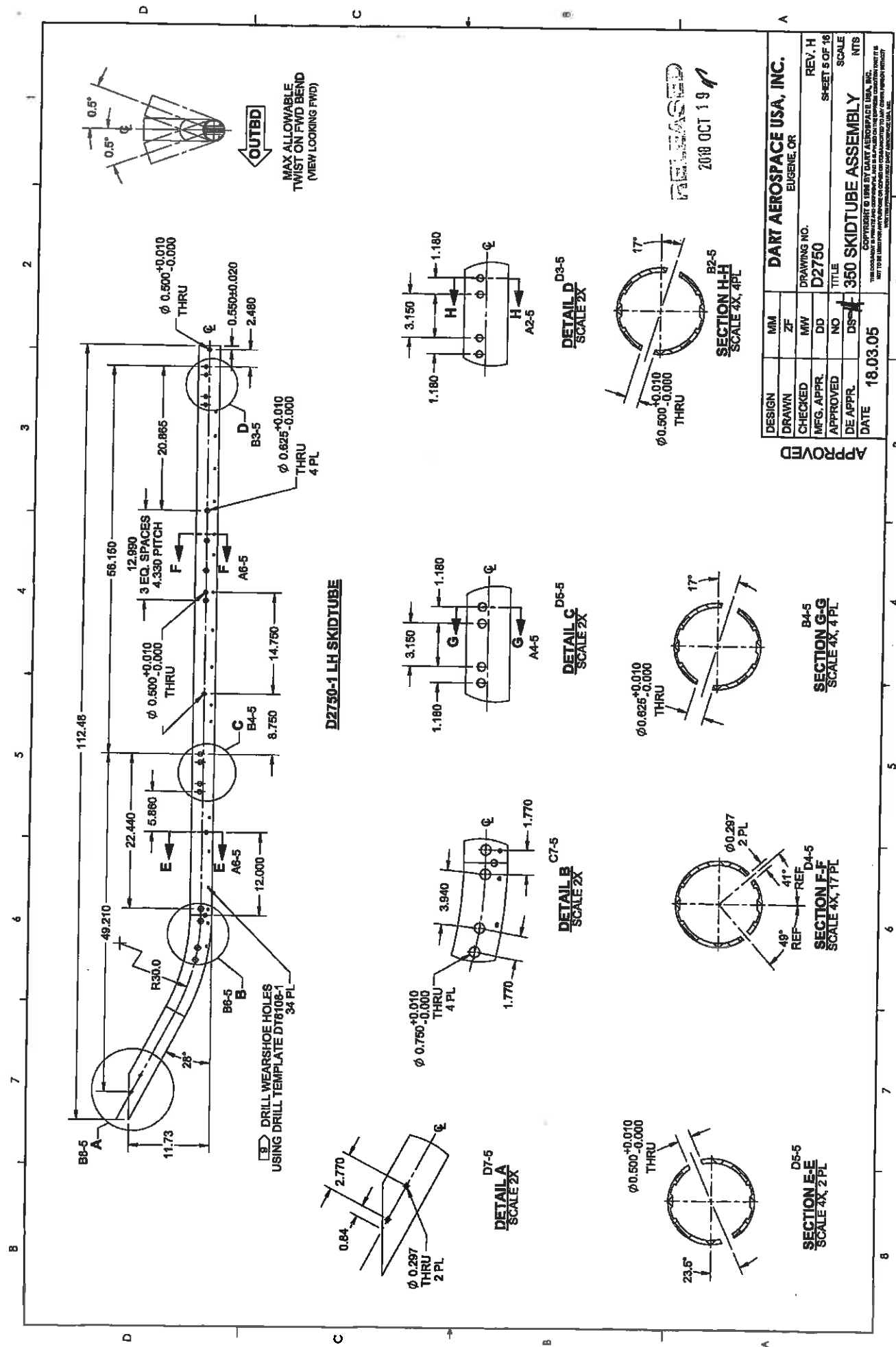
COPYRIGHT © 1988 BY DART AEROSPACE USA, INC.
THIS DRAWING IS THE PROPERTY OF DART AEROSPACE USA, INC.
IT IS TO BE USED FOR THE PURPOSES SPECIFIED ONLY AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.



RELEASED
2018 OCT 19

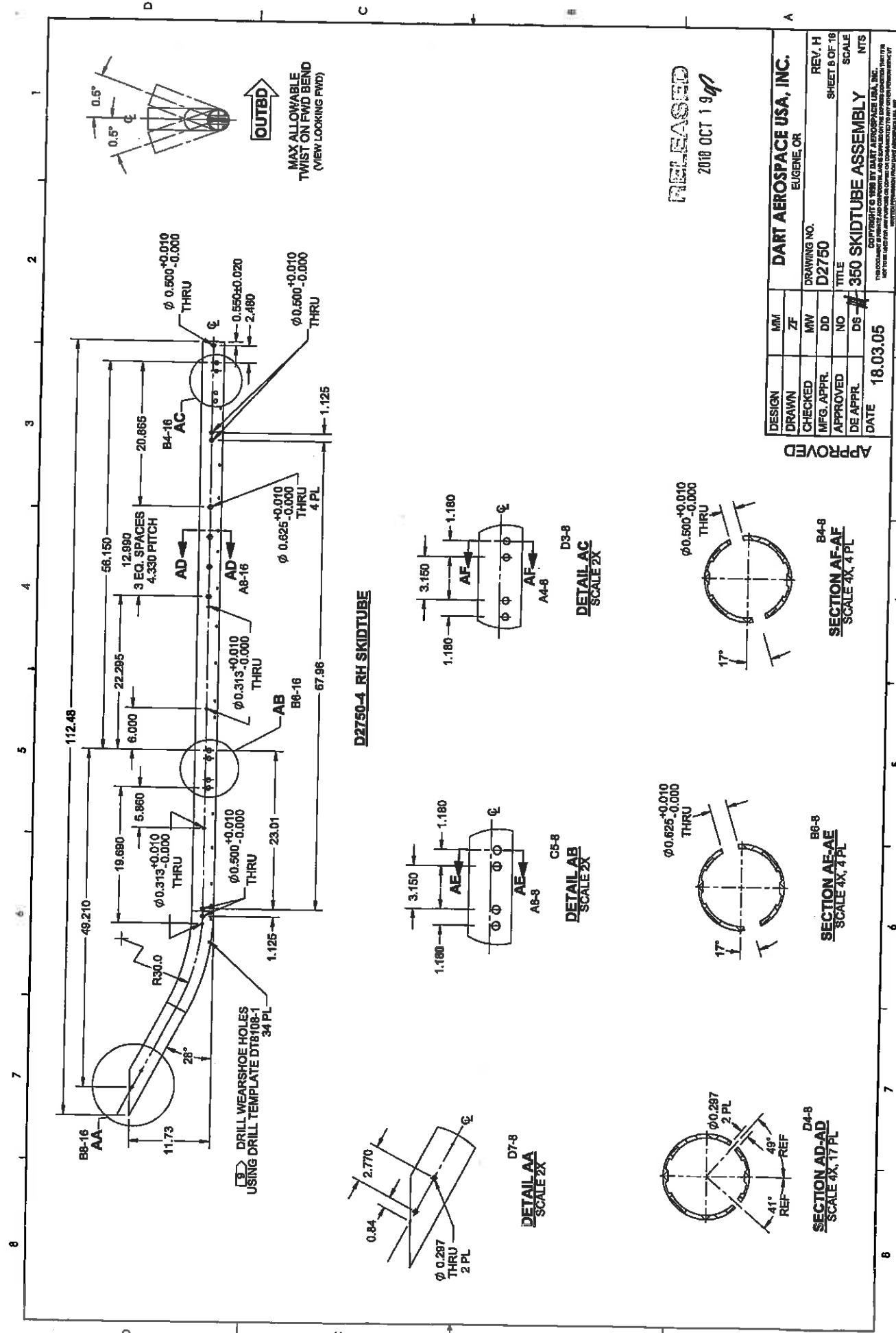
DESIGN		MM	DART AEROSPACE USA, INC.	
DRAWN	ZF		EUGENE, OR	
CHECKED	MM		DRAWING NO. D2750	
MEG. APPR.	DD		REV. H SHEET 4 OF 18	
APPROVED	NO		TITLE 350 SKIDTUBE ASSEMBLY	
DATE	18.03.05		SCALE NTS	

COPYRIGHT © 1994 BY DART AEROSPACE USA, INC.
 THIS DOCUMENT IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE
 NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM WITHOUT PERMISSION



THIS DOCUMENT IS UNCLASSIFIED
DATE 08-11-2011 BY 60322 UCBAW/STP

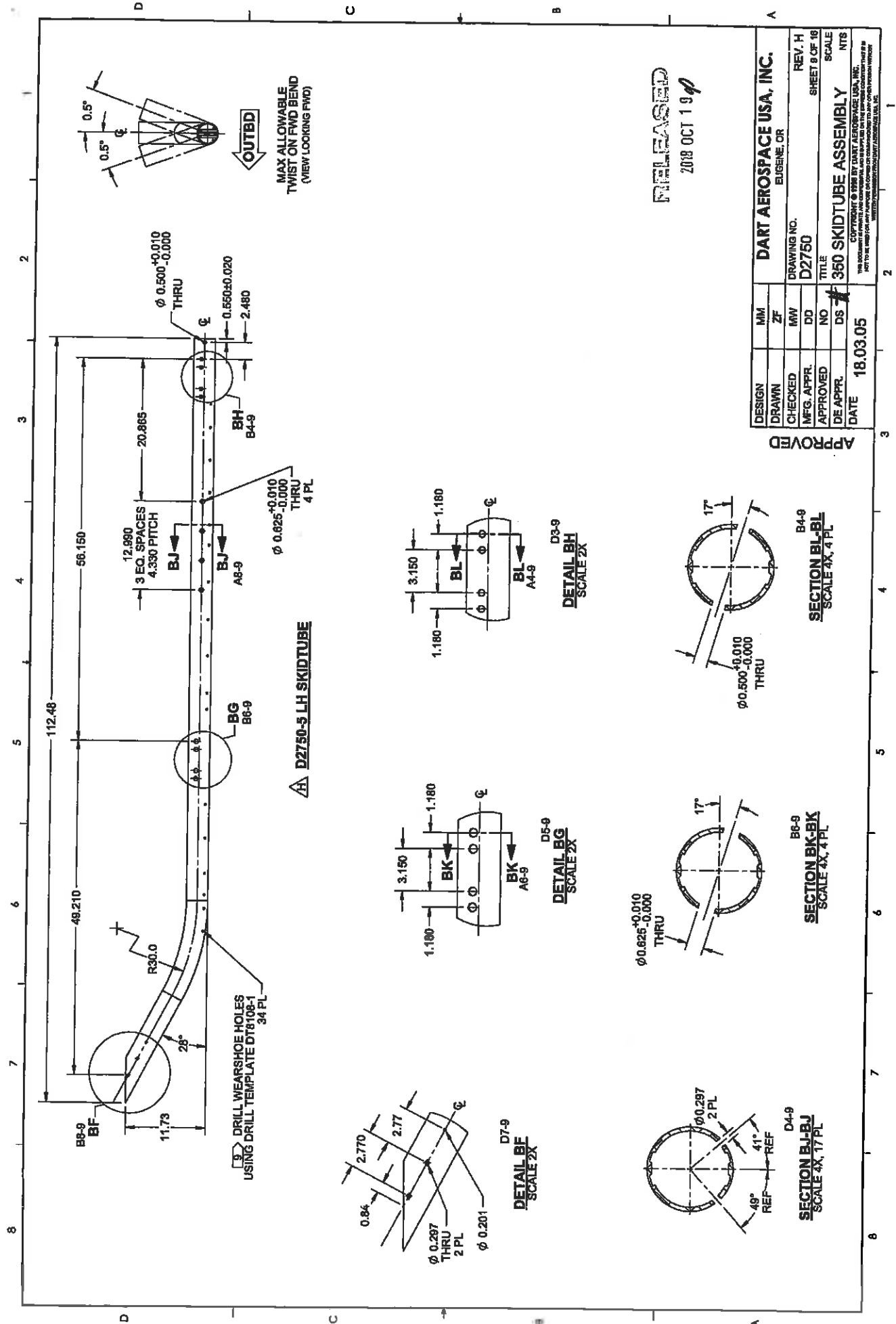




RELEASED
2010 OCT 19 07

DESIGN	MM	ZF	DART AEROSPACE USA, INC.
DRAWN			EUGENE, OR
CHECKED	MM	DD	DRAWING NO. D2750
APPROVED	NO	DD	REV. H
DATE	18.03.05		SHEET 8 OF 18
			SCALE
			350 SKIDTUBE ASSEMBLY
			NTS

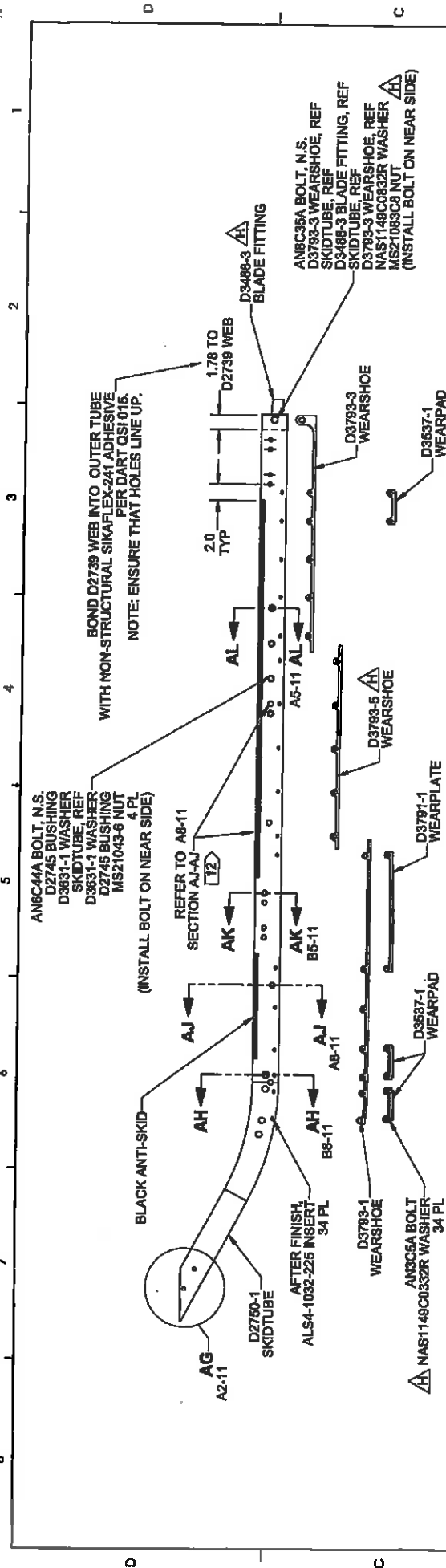
Copyright © 1988 by DART Aerospace USA, Inc.
This drawing and its contents are the property of DART Aerospace USA, Inc.
No part of this drawing may be reproduced without written permission of DART Aerospace USA, Inc.



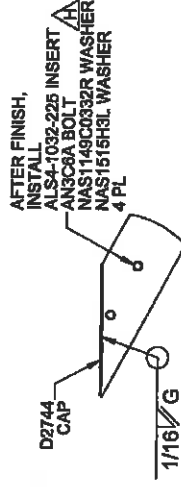
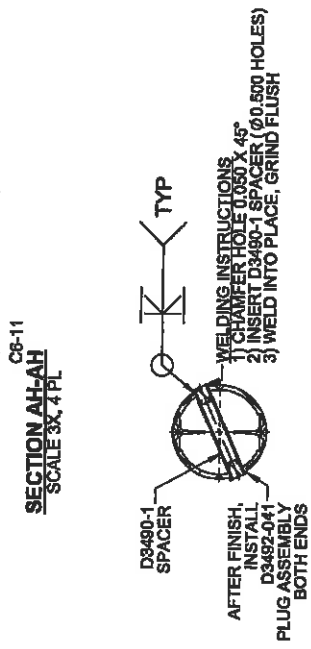
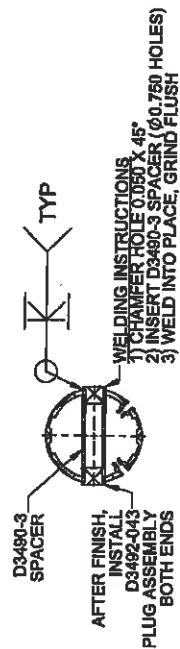
RELEASED
2018 OCT 19

DESIGN	MM	DART AEROSPACE USA, INC.
DRAWN	ZF	EUGENE, OR
CHECKED	MM	DRAWING NO. D2750
MFG. APPR.	DD	REV. H
APPROVED	NO	SHEET 8 OF 18
DATE	DS	TITLE
18.03.05		350 SKIDTUBE ASSEMBLY
		SCALE NTS

COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.
THIS DRAWING IS THE PROPERTY OF DART AEROSPACE USA, INC. AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING BY DART AEROSPACE USA, INC.

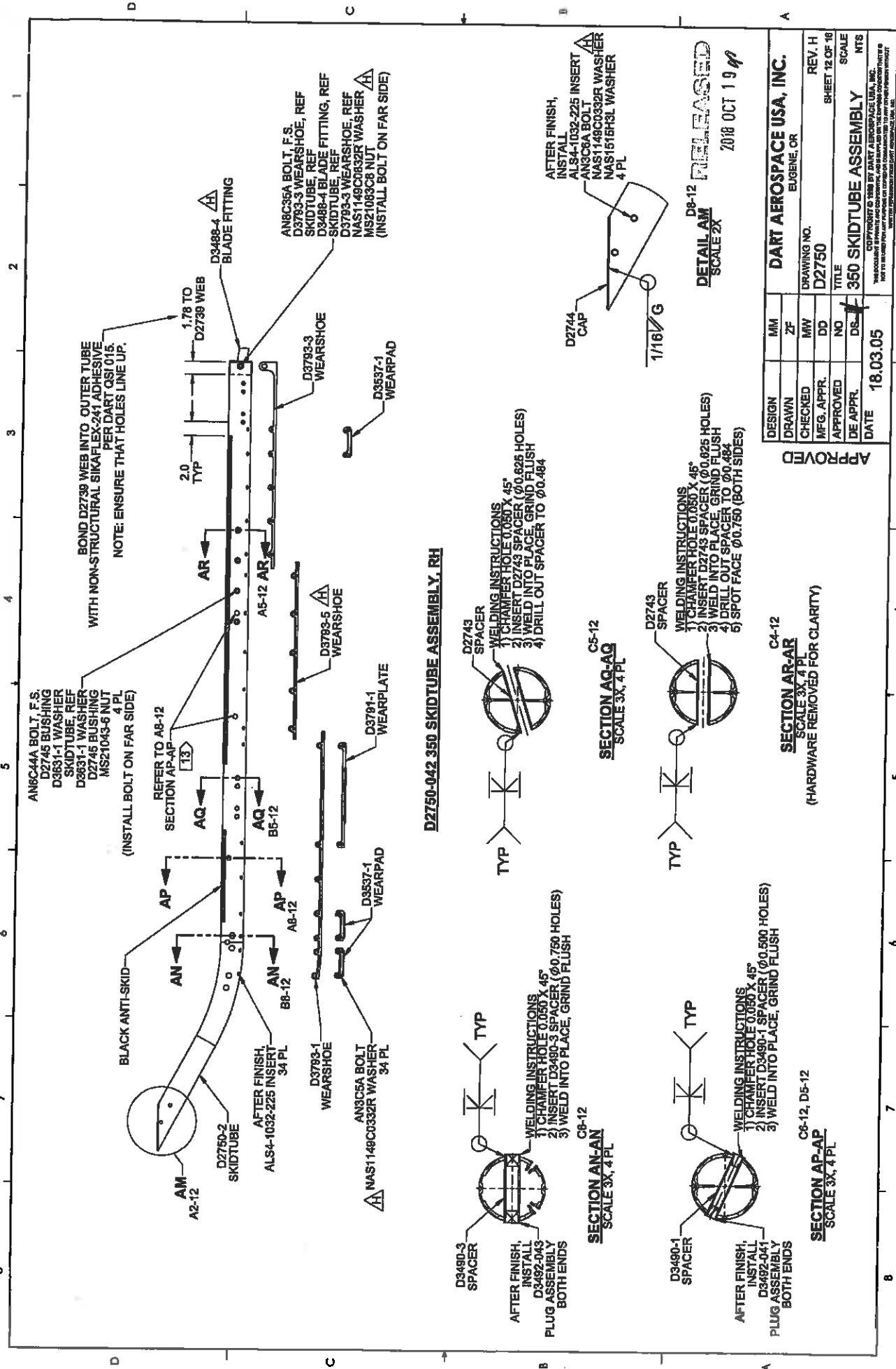


D2750-041 350 SKIDTUBE ASSEMBLY, LH



DETAIL AG
SCALE 2X
D8-11
RELEASED
2010 OCT 19 *dp*

DESIGN	MM	DART AEROSPACE USA, INC. EUGENE OR DRAWING NO. D2750 REV. H SHEET 11 OF 16 SCALE NTS
DRAWN	ZF	
CHECKED	MM	
MFG. APPR.	DD	
APPROVED	NO	
DE APPR.	DS	
DATE	18.03.05	350 SKIDTUBE ASSEMBLY CONTRACT # 988 BY DART AEROSPACE USA, INC. THIS DRAWING IS UNCLASSIFIED, AND IS NOT A CONTROL DRAWING. IT IS THE PROPERTY OF DART AEROSPACE USA, INC. AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.







AFTER FINISH,
 INSTALL
 ALS-4-1032-225 INSERT
 AN3C6A BOLT
 MS114QC353R WASHER
 MS1515HXL WASHER
 4 PL
 AN3C34A BOLT, N.S.
 MS114QC353R WASHER, 2x
 MS21043-NUT
 (INSTALL BOLT ON NEAR SIDE)

DESIGN		MM	DRAWING NO.		REV. H
DRAWN		ZF	D2750		
CHECKED		MM	SHEET 16 OF 14		SCALE
INFG. APPR.		DD	DATE		
APPROVED		NO	TITLE		350 SKIDTUBE ASSEMBLY
DE APPR.		DS	DATE		
18.03.05		COPIRIGHT © 1984 BY DART AEROSPACE USA, INC. ALL RIGHTS RESERVED. NO PART OF THIS PUBLICATION MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.			

FILED
2018 OCT 19
42

A

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



DISPOSITION		DEPARTMENT/PROCESS	
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐
Part No. _____	Skid-tube ☐ Machining ☐ Large Fab ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: _____	Sequence #: _____	QTY Affected: _____	
Description Work Order Deviation		Disposition	
Completed By		MRB (QSI042)	
Lead hand / Supervisor			
QC / QA Coordinator			
FAULT CATEGORY			
Root Cause		FAULT CATEGORY	
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐
Human Factors ☐	Other/Details: _____		